

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014745**Date Inspected:** 02-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 4A located on East tower Lift-2 cross bracing connection plate WD1 – GUSA3 – 3 – 77M – E.

Welder is identified as 040610. ZPMC Quality Control (QC) Inspector is identified Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2211 – Tc – U5b – FCM.

Weld joint # 4A located on South tower Lift-2 cross bracing connection plate WD1 – GUSA3 – 3 – 77M – S.

Welder is identified as 056200. ZPMC Quality Control (QC) Inspector is identified Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2211 – Tc – U5b – FCM. (See attached photo)

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This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 25 located on Tower Strut ED1 – STSA4 – 10 – 119M – 1. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2113. (See attached photo)

Weld joint # 44 located on Tower Strut ND1 – STSA4 – 10 – 119M – 1. Welder is identified as 251194. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4113.

Weld build-up using Flux Cored Arc Welding (FCAW):

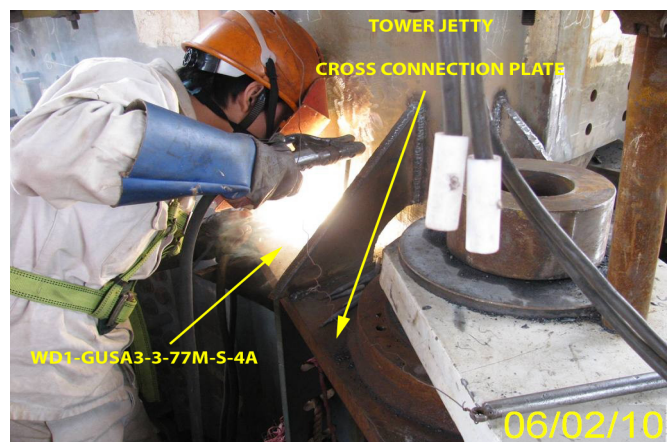
Weld build up being performed according to the weld repair report #T-WR3307 located on Apron plate ring beam # SD1-A66. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) – Repair.

Weld build up being performed according to the weld repair report #T-WR3329 located on 9M outside Diaphragm # SD1-A6. Welder is identified as 049220. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair.

MEASUREMENTS ON SHEAR PLATE

This QA Inspector carried out the measurements on Shear Plate # WD1-A28 and SD1-A20 to check the distance from stiffener to stiffener and the edge of the base plate anchor bolt holes to the side of the type-2 bearing stiffeners. Measurements were recorded on the data sheet and submitted to the assigned task leader.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
